

Date: Wednesday, 30/01/2008 2:24:02 PM
 User: Linda Lacelle

Process Sheet

u/b
 Splitter
 8/08/03/19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CYCLIC STICK
 Job Number : 37120 -2
 Estimate Number : 13108
 P.O. Number :
 This Issue : 30/01/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3630041
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3630 REV A
 Previous Run : Project Number : N/A
 Written By : Drawing Revision : A
 Checked & Approved By : Material :
 Comment : Est Rev'd 07-12-19 new issue ECN960 DD Due Date : 06/02/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR1125W065	304 RD Tube 1.125 x .065w
Comment: Qty.: 2.4497 f(s)/Unit Total: 12.2483 f(s) Material: 304/316 SS Seamless Tubing 1.125" OD x 0.065" wall(M304TR1125W065) Batch: M107149		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Cut to length as per Dwg D2536
- 2-Deburr
- 3-form D3630-5 as per dwg D3630

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld as per dwg D3630 and QSI004
- 2- Grind weld flush

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CYCLIC STICK

Job Number: 37120

Part Number: D3630041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Drill holes as per dwg D3630
2- deburr

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- remove all scratches

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57364

12.0

QC21

FINAL INSPECTION/W/O RELEASE

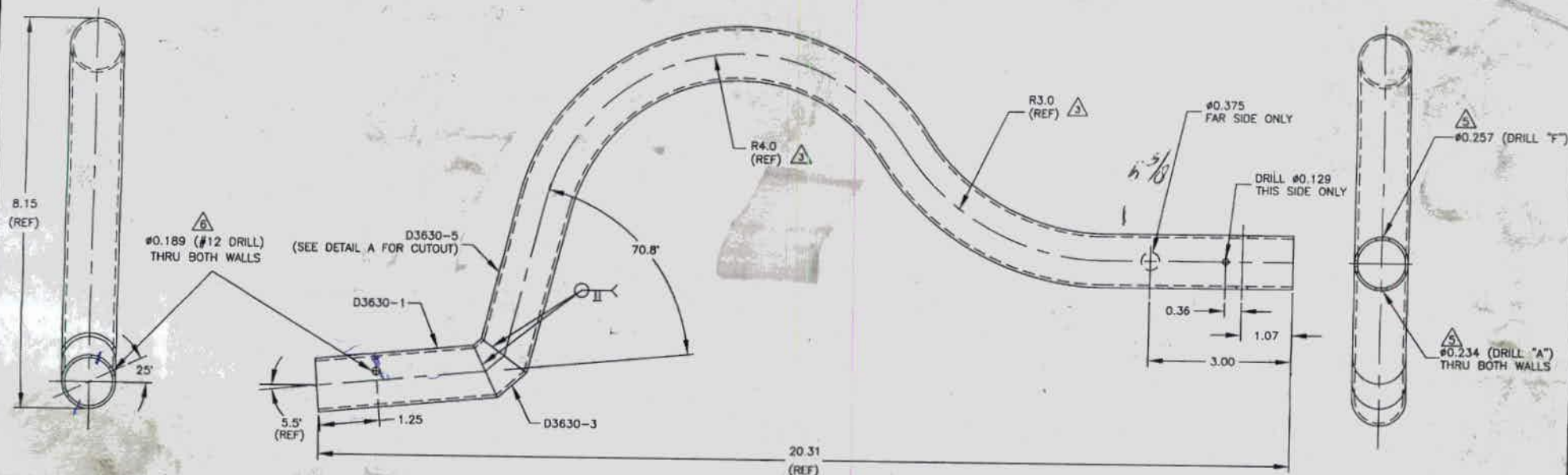


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-03-24



D3630-041 CYCLIC STICK (REPLACES GENEVA P/N G10202)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING 1.125" OD X 0.065" WALL (REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT3940
- 4) WELD PER DART QSI 004
- 5) DRILL #0.234 THRU BOTH WALLS THEN DRILL #0.257 THRU ONE WALL AS SHOWN
- 6) DRILL #0.189 THRU BOTH WALLS AT 25° OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT PERMANENT INK MARKER

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3630-041	CYCLIC STICK
1	D3630-1	TUBE
1	D3630-3	TUBE
1	D3630-5	TUBE

D3630-1
(REPLACES GENEVA P/N G10202-1)

D3630-3
(REPLACES GENEVA P/N G10202-2)

D3630-5
(REPLACES GENEVA P/N G10202-3)

DETAIL A: CUTOUT

RELEASED
07/11/29

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A	07.05.11	NEW ISSUE: REPLACES G10202
DESIGN	CLB	DRAWN BY <i>SC</i>
CHECKED	APPROVED	<i>[Signature]</i>
DATE	07.05.11	TITLE
		CYCLIC STICK
		DART AEROSPACE USA, INC. PORT HAVEN, MA
		DRAWING NO. D3630
		REV. A
		SHEET 1 OF 1
		SCALE
		1:2

